

Date: Tuesday, 02/10/2007 12:53:40 PM  
User: Linda Lacelle

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 34964		
Estimate Number	: 12578		
P.O. Number	: <i>N/A</i>	Part Number	: D3560041
This Issue	: 02/10/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3560 <i>UNDER REVIEW</i>
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 34474	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 09/10/2007 Qty: 5 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est Rev. New Issue 07.05.24 EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 PULL FROM STOCK:		
2.0	D3560041	ARM WELDMENT
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) ARM WELDMENT B <i>332643-5</i> <del><i>334477-2</i></del> B <i>332643-5</i> <del><i>334477-2</i></del>		
3.0	D35921	PLATE
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) PLATE <i>334478-3</i> <del><i>334260-2</i></del>		
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1  1-Weld assembly as per dwg D3560		
5.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		

*[Handwritten signatures and dates]*  
07.10.02 5  
07.10.02 5  
07.10.02 5  
02/10/03 (25)

Date: Tuesday, 02/10/2007 12:53:40 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34964

Part Number: D3560041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

D 07-10-03 (5)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

A.M 07-10-03

(5) (710)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BE

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SE 07-10-03

(5)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

SE 07-10-03

(5)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

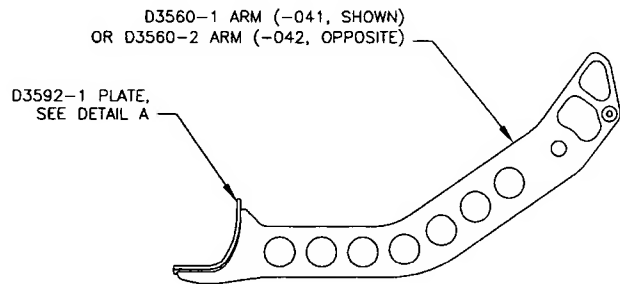
SE 07-10-04

Job Completion

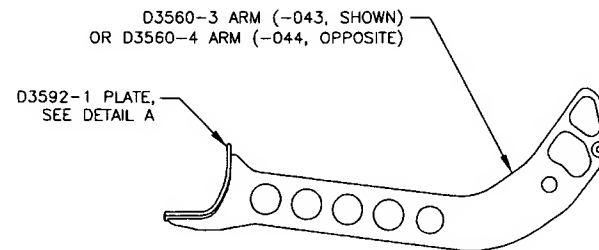


W 07-10-04

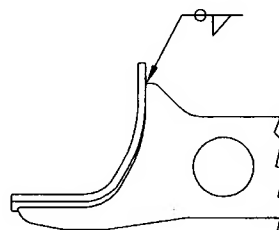
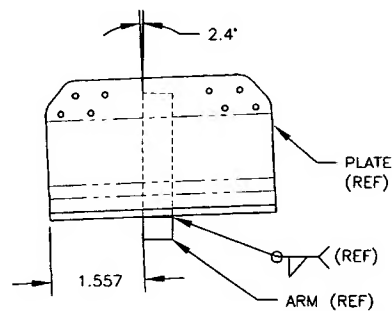
19964  
D3560



D3560-041 ARM WELDMENT (SHOWN),  
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),  
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A  
(SCALE 1:1)

**GENERAL NOTES**

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

**RELEASED**  
07.06.19

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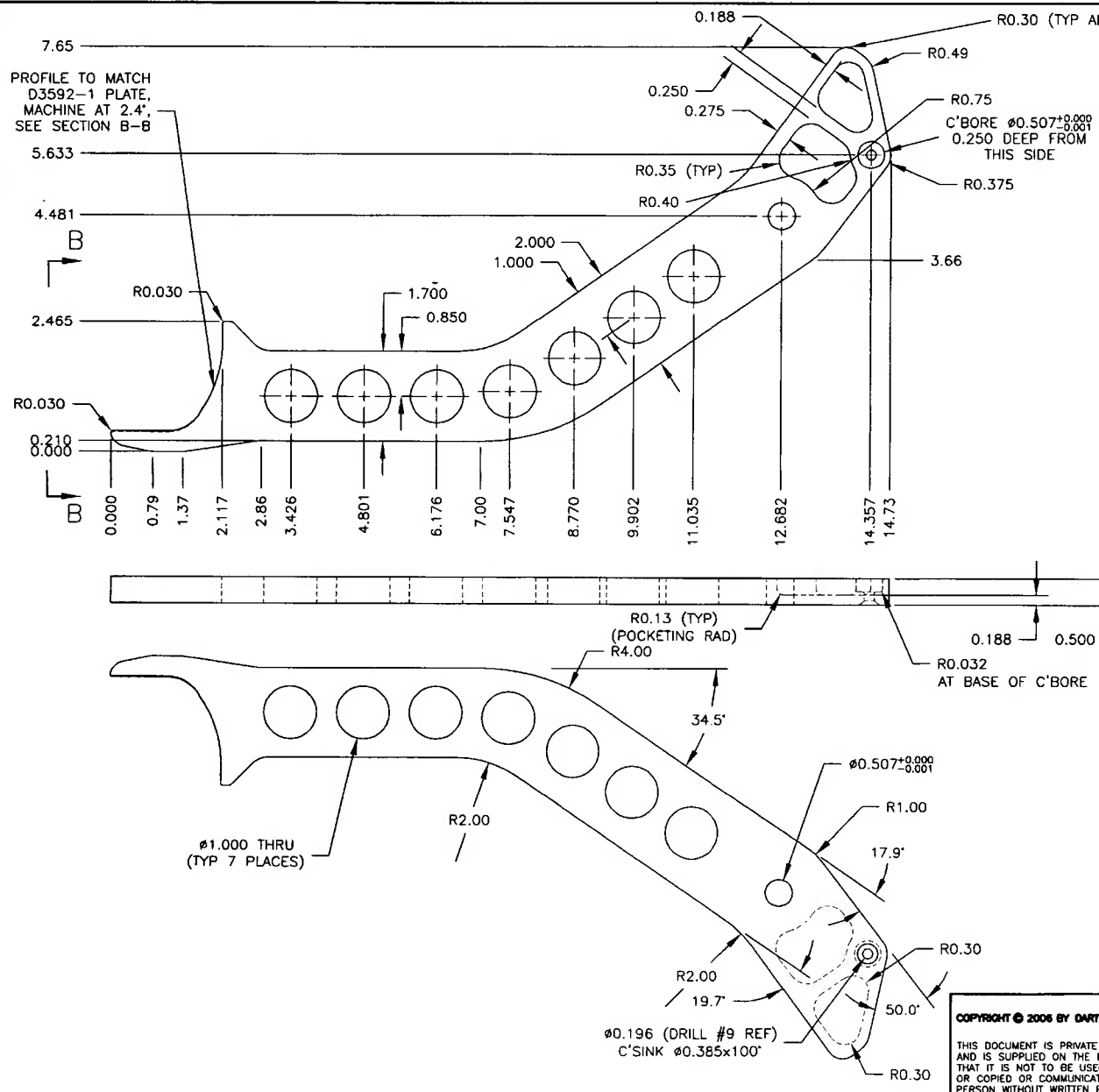
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C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	q	DRAWN BY q
CHECKED	H	APPROVED H
DATE	07.06.19	TITLE
		ARM WELDMENT
		SCALE 1:4

**DART** DART AEROSPACE LTD.  
HARVESBURY, ONTARIO, CANADA

DRAWING NO. D3560  
SHEET 1 OF 3

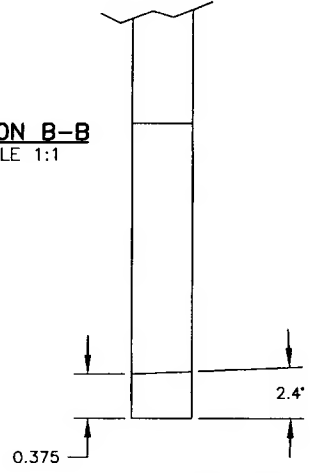
REV. C



**D3560-1 ARM (SHOWN), D3560-2 ARM (OPPOSITE)**

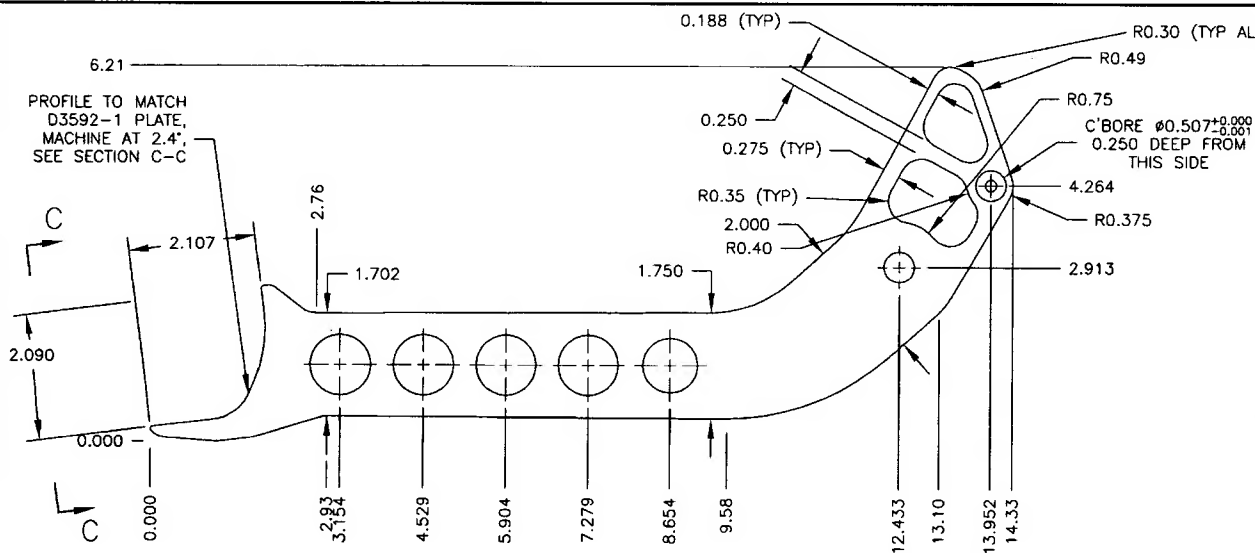
- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK  
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

**SECTION B-B**  
SCALE 1:1



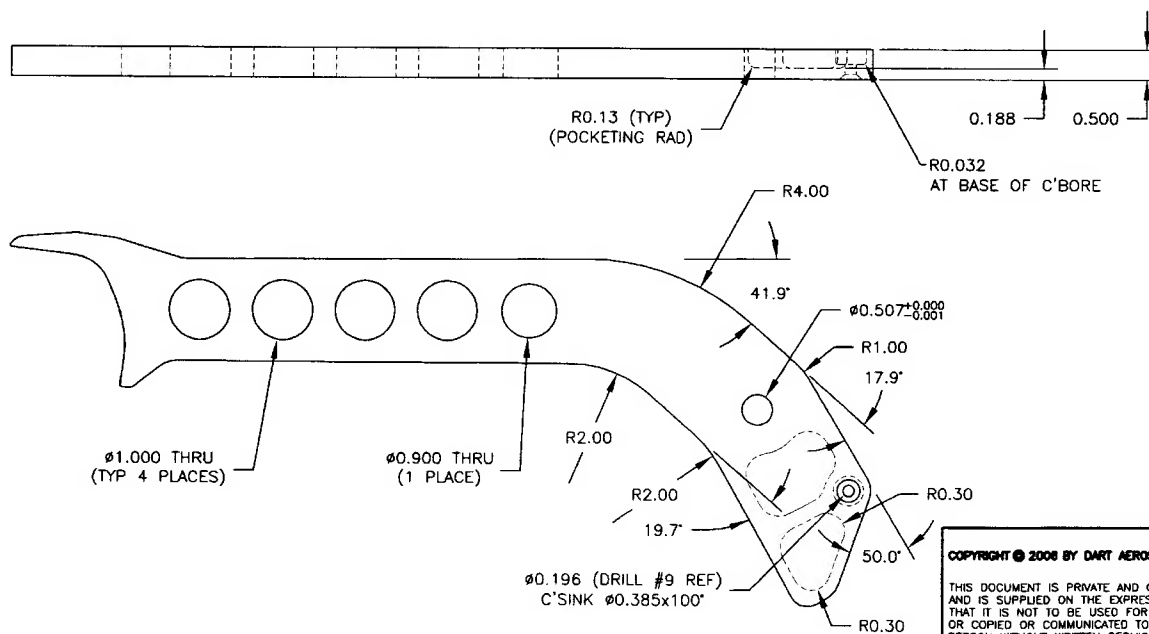
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07.06.19

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		DATE		DRAWING NO.	REV. C
		07.06.19		D3560	SHEET 2 OF 3
				TITLE	SCALE
				ARM WELDMENT	1:2

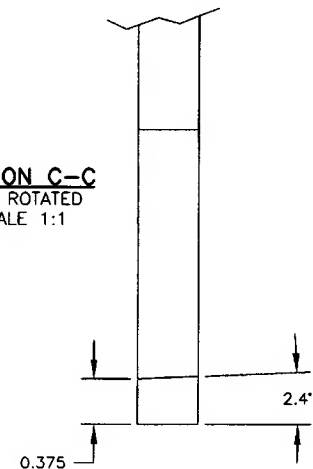


**D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)**

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK  
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



**SECTION C-C**  
VIEW ROTATED  
SCALE 1:1



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DATE	07.06.19	TITLE	ARM WELDMENT	REV. C	SHEET 3 OF 3
				SCALE	1:2